

Work Order ID 70124

Friday, May 27, 2011 10:53:51 AM



Page 1

Item ID: D412-704-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Assembly (205/212/214/412)

Start Date: 6/2/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *11-05-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-704-041	Rev A								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble pedal as per Dwg D412-704-041 Tighten & Torque Bolts as per Dwg D412-704-041								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

*EP 11/06/02 (2)**Sub 6103**(42)**11/6/35 (2)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

[illegible]

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Accept

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Setup Start



Stop



■■■■■

Cust Item ID:

11

Customer:

Run Start

[REDACTED]

Stop

[illegible]

**Insp.
Stamp**

0.00

[illegible]

8 ulobelo3

QC

Memo

Quality Control

0.00

140

Identify as per dwg & Stock Location: 197

0.00



0.00

Packaging

Memo

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Memo

Quality Control

11/6/17 AG

mt 11-06-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 27, 2011 10:53:58 AM

Page 1

Work Order ID: 70124

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)



Start Date: 6/2/2011

Required Date: 6/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF
 IPP Rev:C 06.03.08 Re-format EC
 IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
 IPP Rev:E 07.05.02 Reformat EC
 IPP Rev:F 08-10-08 as per revB DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A 		Purchased	No			100	Each	193.0000	1	2			
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				193					
				117313				59					
				117795				134					
AN315-4R 		Purchased	No			100	Each	53.0000	1	2			
Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				53					
				17566				53					
AN4-10A 		Purchased	No			100	Each	192.0000	1	2			
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				192					
				116419				17					
				117313				50					
				117619				125					

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 70124

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 6/2/2011

Required Date: 6/6/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-12A Purchased No 100 Each 213.0000 2 4
Bolt

Location	Loc Qty	Loc Code
ST357	213	
115422	113	
117508	100	

AN4-13A Purchased No 100 Each 150.0000 1 2
Bolt

Location	Loc Qty	Loc Code
ST357	150	
117628	150	

AN960JD10 NAS1149D0363J Purchased No 100 Each 0.0000 5 10
Washer 47 M116583 (102)

AN960JD416 NAS1149D0463J Purchased No 100 Each 0.0000 11 22
Washer 47 M117291 (22)

AN960JD416L NAS1149D0416J Purchased No 100 Each 3.0000 3 6
Washer 47 M114884 (6)

Location	Loc Qty	Loc Code
FP-B	3	
110153	3	

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W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 70124

Parent Item: D412-704-041


Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 6/2/2011


Required Date: 6/6/2011

Start Qty: 2.00


Required Qty: 2.00


D3204-041 Manufactured No 100 Each 2.0000 1 2

 Release Pedal Assembly

Location	Loc Qty	Loc Code
GA	2	
64815	2	


D3205-1 Manufactured No 100 Each 2.0000 1 2

 Pedal Bracket

Location	Loc Qty	Loc Code
GA	2	
64816	2	

~~D3205-3~~ Manufactured No 100 Each 0.0000 1 2

 Back Plate

D3206-1 Manufactured No 100 Each 3.0000 1 2

 Pedal Arm

Location	Loc Qty	Loc Code
GA	3	
55732	3	

D3209-041 Manufactured No 100 Each 3.0000 1 2

 Bracket Assembly

Location	Loc Qty	Loc Code
GA	3	
60295	1	
65154	2	

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Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Friday, May 27, 2011 10:53:59 AM

Page 4

Work Order ID: 70124

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 6/2/2011

Required Date: 6/6/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

100

Each

2,156.000

1



Nut



EPB 11/06/02

Location

Loc Qty

Loc Code

ST300

2156

116391

11

116540

179

116549

766

117441

800

117601

400

2

MS21042L4

Purchased

No

100

Each

4,525.000

5



Nut



EPB 11/06/02

Location

Loc Qty

Loc Code

ST300

4525

116823

725

117441

3000

117601

800

10

MS24694-S102

Purchased

No

100

Each

48.0000

1



Screw



EPB 11/06/02

Location

Loc Qty

Loc Code

ST288

48

114382

48

2

MS9519-10

Purchased

No

100

Each

36.0000

1



Bolt



EPB 11/06/02

Location

Loc Qty

Loc Code

ST296

36

100290

36

2

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W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 70124

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 6/2/2011

Required Date: 6/6/2011

Start Qty: 2.00

Required Qty: 2.00

AN3-6A

Purchased

No

120

Each

366.0000

2



Bolt

Location

ST351

Loc Qty

366

66

300

Loc Code

0.0000

4

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each



Washer

MS21042L3

Purchased

No

120

Each

2,156.000

2



Nut

Location

ST300

Loc Qty

2156

11

179

766

800

400

116391

116540

116549

117441

117601

Loc Code

4

8

11/17/29/1

4

11/6/13 SP2

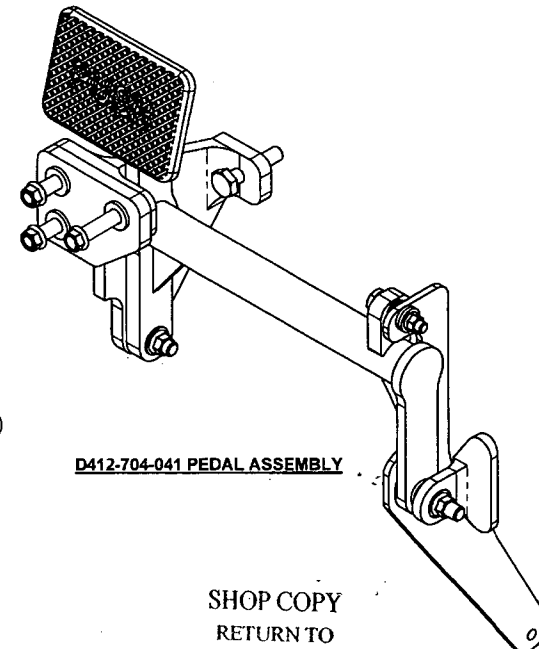
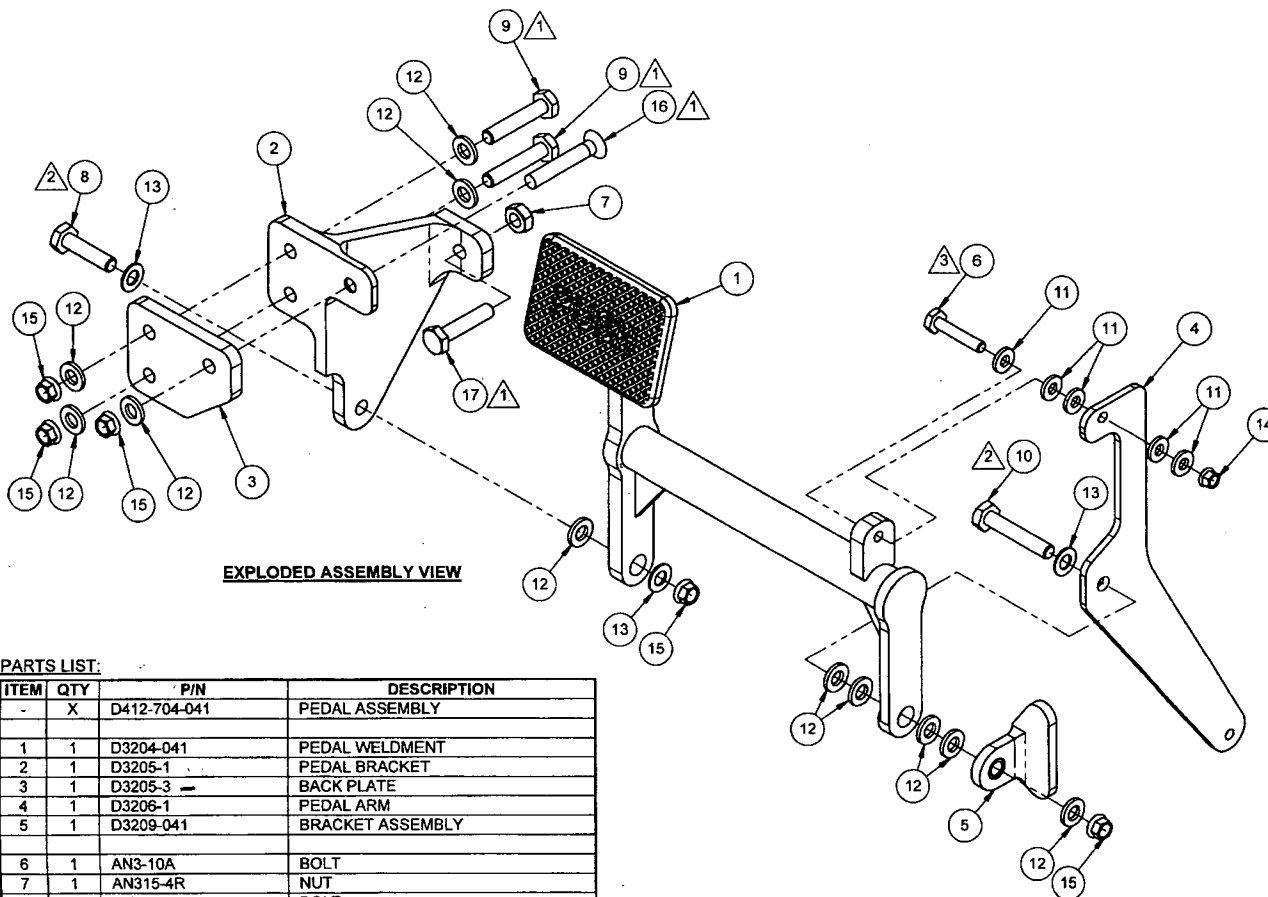
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D412-704-041 PEDAL ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70124

PL 11-05-27

RELEASED

07-01-30

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE		
DESIGN	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED		REV. A
DATE	07.01.23	TITLE	SHEET 1 OF 1
		PEDAL ASSEMBLY	SCALE
			1:2

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